

Date:

Monday, 02/06/2008 4:37:18 PM

User:

Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number	: 39650		
Estimate Number	: 12779		
P.O. Number	:	Part Number	: D350600242
This Issue	: 02/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN REV.C PG11,18-21
First Issue	: / /	Project Number	: N/A
Previous Run	: 39642	Drawing Revision	: C
		Material	:
Written By	:	Due Date	: 01/07/2008
Checked & Approved By	: <u>JLD 08.10.02</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD 08.6.09



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

5/10/02

2.0	39650A	SPACEPOD BODY RH
-----	--------	------------------



Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch:

D 39650A

BR 08-09-25

3.0	39650B	SPACEPOD DOOR RH
-----	--------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

D3186-4

Batch:

D39650B

BR 08-09-25

4.0	D31872	Spacepod Floor
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2

Floor

B35394

B31834

SP

5.0	ALS41032130	Insert
-----	-------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch: 4105819

8/9/14

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



M106150



Q

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer - Countersunk

8/9/4

SD

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

BR 08-09-17

①

8.0

QC5

INSPECT WORK TO CURRENT STEP



10-09-24



Comment: INSPECT WORK TO CURRENT STEP

9.0

D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: B 30632

BR 08-09-24 ①

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986-1 D 3187-T1

PTO →
BR 08-09-24 ①

11.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B41177

SP

12.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD

B37674

8/9/4

Q

34

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-09-24	10.0	TEMPLATE PART # CHANGE FOR 03187-T1	BR	08.09.24			
		perm change	MA	08/09/30		08-09-25	08-09-25
		ESTIMATE # 12779					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: M108670

scf

14.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B39678

scf

15.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B38807

scf

16.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: M3459

scf

17.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B35454

scf

18.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30630

scf

19.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104603

8/4/4

scf

W/O:		WORK ORDER CHANGES					
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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108335

SP

21.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M108283

SP

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step separates hardware, previous steps is for body & floor****

23.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M108335

SP

24.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108335

SP

25.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M107101

SP

26.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108283

8/9/14

(14)

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B39669

SP

28.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B39678

SD

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: B39783

SY

30.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: B39813

SD

31.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B33894

SP

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M108169

SD

33.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M109059

8/9/14

(1x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108701

SP

35.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B38680

SP

36.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B36924

SP

37.0

D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: B30679

SP

38.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104603

SP

39.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M108335

SP

40.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108283

2/9/4

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch: B32617

54

42.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M9216

54

43.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M104603

9/9/4

50

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: M107908 expire date: 09-03-20

A/R Milled fibres batch: M100859

2- Prime (Gues) per QSI 005, as necessary M 109241

3- Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: M105623

BR 08-09-18

BR 08-09-24

PTD

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-09-25

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M109219

08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-09-25	44.0	A step to prime (Grey) will be needed, to prime as necessary per Q51005, with hardware B#s: Primer B#s 109241 perm-change.	MM/BR	08-09-25			
		ESTIMATE # 12779 (See W/O 39188)					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M. 08/09/26 (1X)

48.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

41361
336263

8/9/26

(1X)

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/09/26

50.0

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SWITCH RELOCATION KIT

36037

SS 08/09/26 (XU)

51.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label
batch: 32470

SS 08/09/26 (XU)

52.0

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: 35455

SS 08/09/26 (XU)

53.0

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STRUT
batch: 36226

SS 08/09/26 (XU)

54.0

D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CARBON STEEL GAS SPRING
batch: 32644

SS 08/09/26 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39650

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 37674

SS 08/09/26 (X)

56.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 108672

SS 08/09/26 (X)

57.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 41177

SS 08/09/26 (X)

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/09/26 (X)

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: B

SS 08/09/26 (X)

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

B 39 650

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

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ENGINEERING

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SUBJECT TO AMENDMENT

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WITHOUT NOTICE
WORK ORDERRevision: C NO. 37650
Date: 07.02.20

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								3	M81824/1-2	SPLICE
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD DOOR.

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

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WITHOUT NOTICE
WORK ORDER

NO. 37050

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Revision: C

Date: 07.02.20

Date: Monday, 02/06/2008 4:37:21 PM
 User: Julie Lecocq

Process-Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	39650A		
Estimate Number :	12596		
P.O. Number :		Part Number :	D31882M
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3188 REV.E
First Issue :	/ /	Project Number :	N/A
Previous Run :	39642A	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :	<u>JULIE 08.10.08</u>	Due Date :	01/07/2008
Comment :	Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		
		Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Insert
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8	D2213	Spacer
---	-------	--------

Batch: 30167

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 10496
 Description: D3188-2M BODY
 SHIP: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:37:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY_RH

Job Number: 39650A

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

Scanned 08/09/29

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D350-666-242 B39650

PK 08-09-25

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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07.04.02

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CHECKED	CE	APPROVED	AK	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 1 OF 11
		SCALE	NTS	
A		03.04.03	NEW ISSUE	
B		06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C		06.12.13	REMOVED D0600-XXX LABELS	
D		07.02.22	UPDATE DIMENSIONS	
E		07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 31020H

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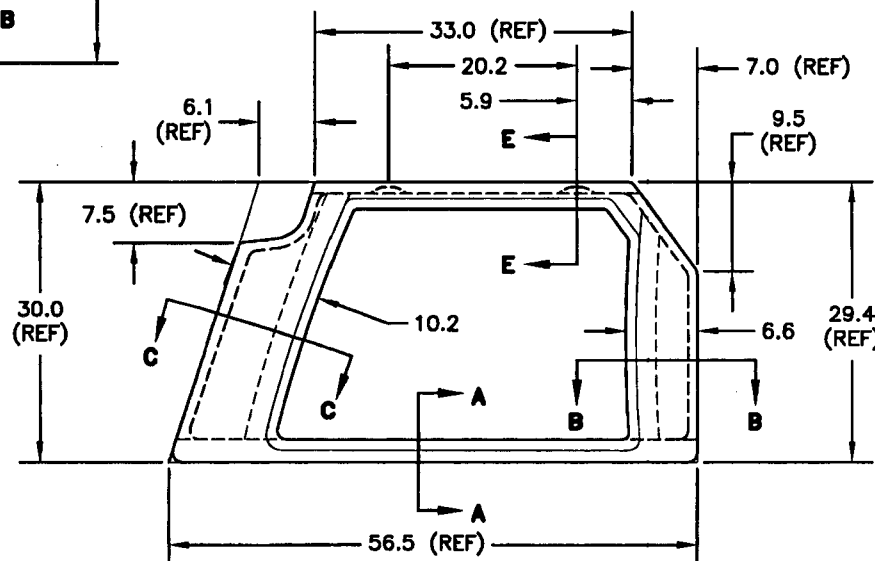
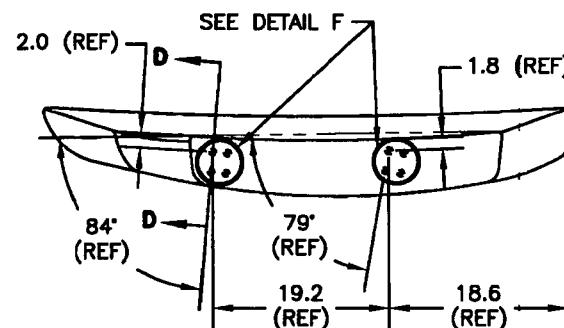
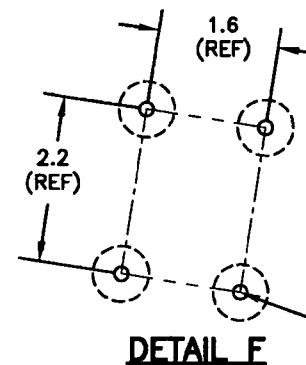
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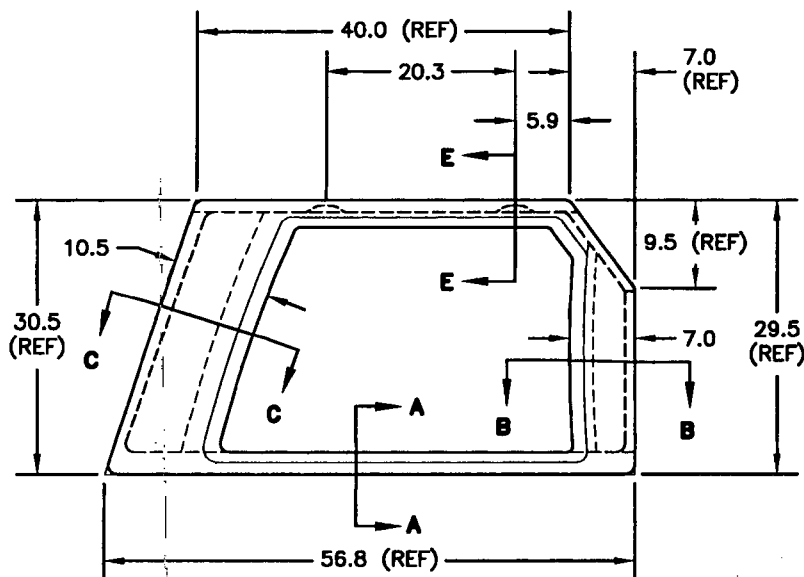
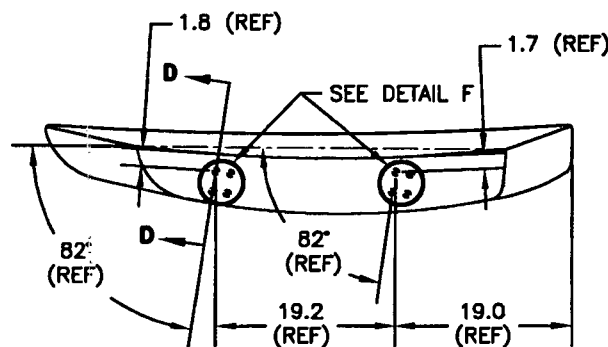
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07-04-07

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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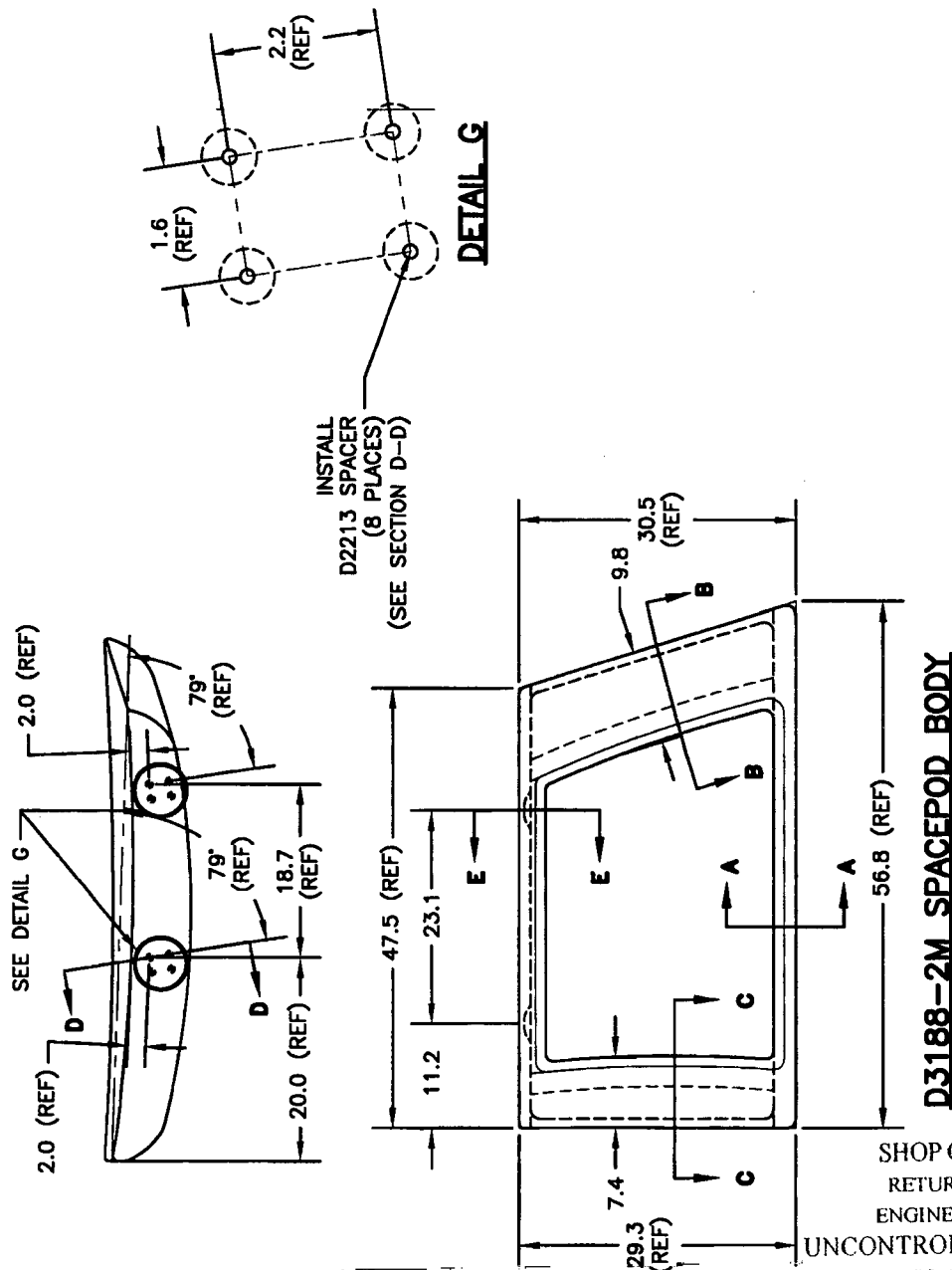
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET	2 OF 11	SCALE
				NTS

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.01 *[Signature]*



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D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

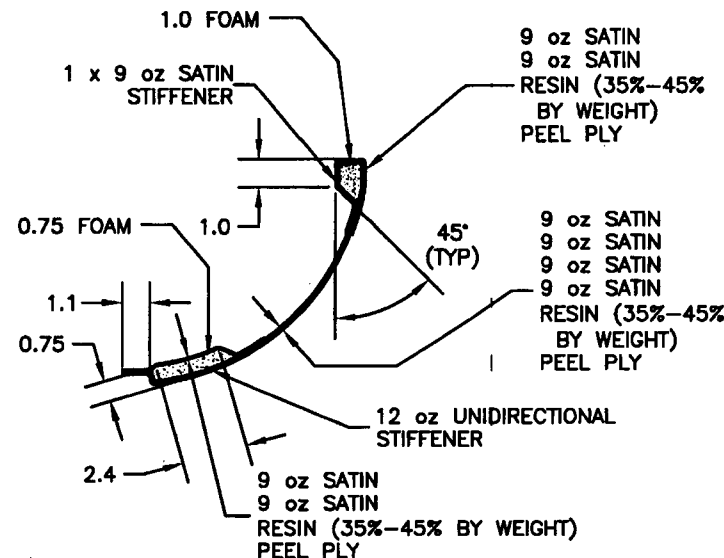
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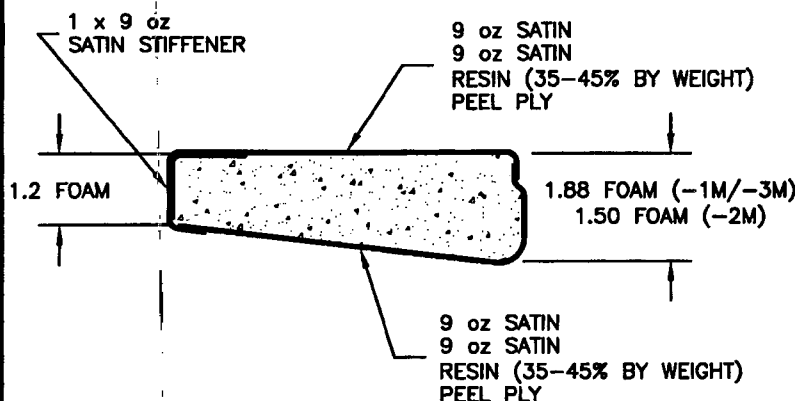
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DATE	07.04.02	TITLE	D3188	REV. E
		SPACEPOD BODY		SHEET 4 OF 11
				SCALE
				NTS

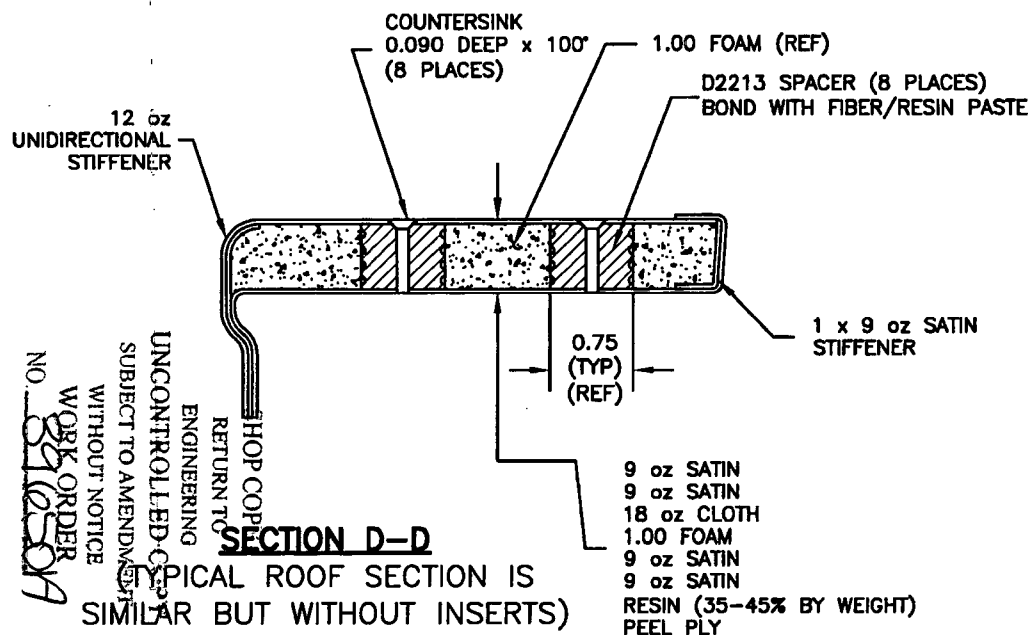
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SECTION B-B
(SECTION C-C OPPOSITE)

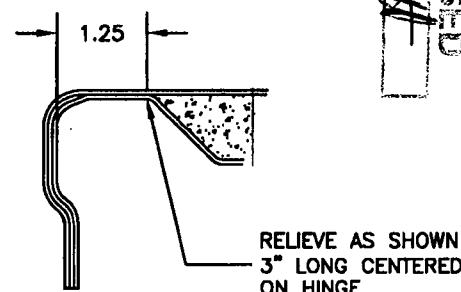


SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D

(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

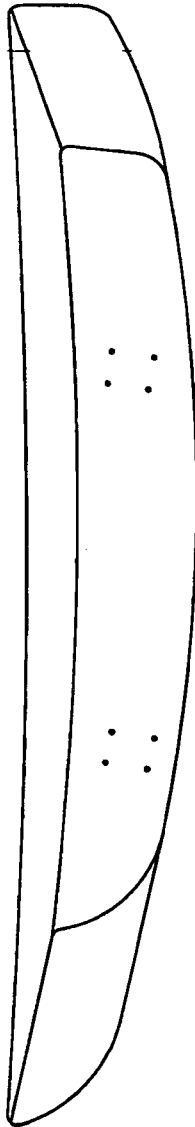
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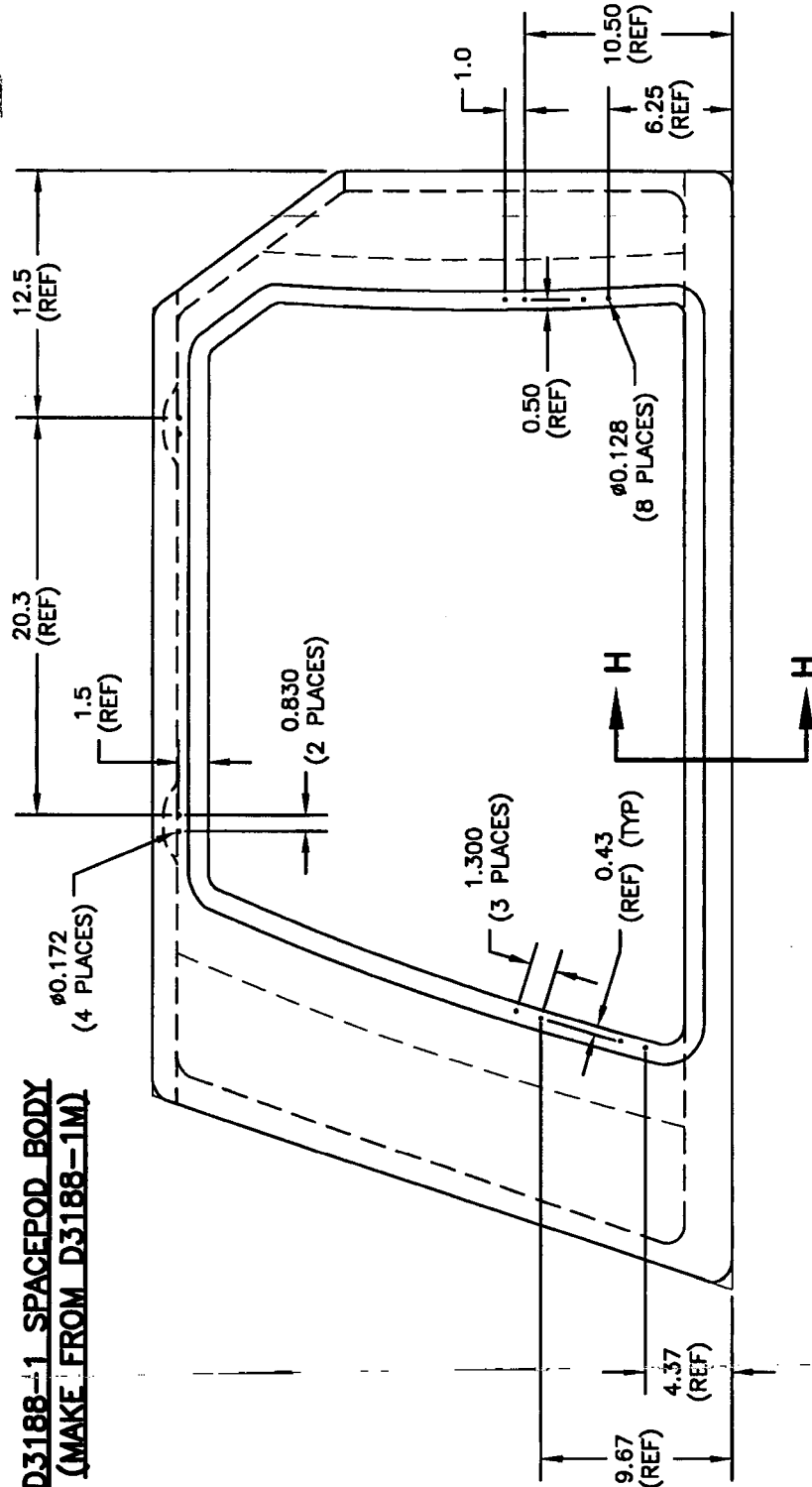
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.02



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

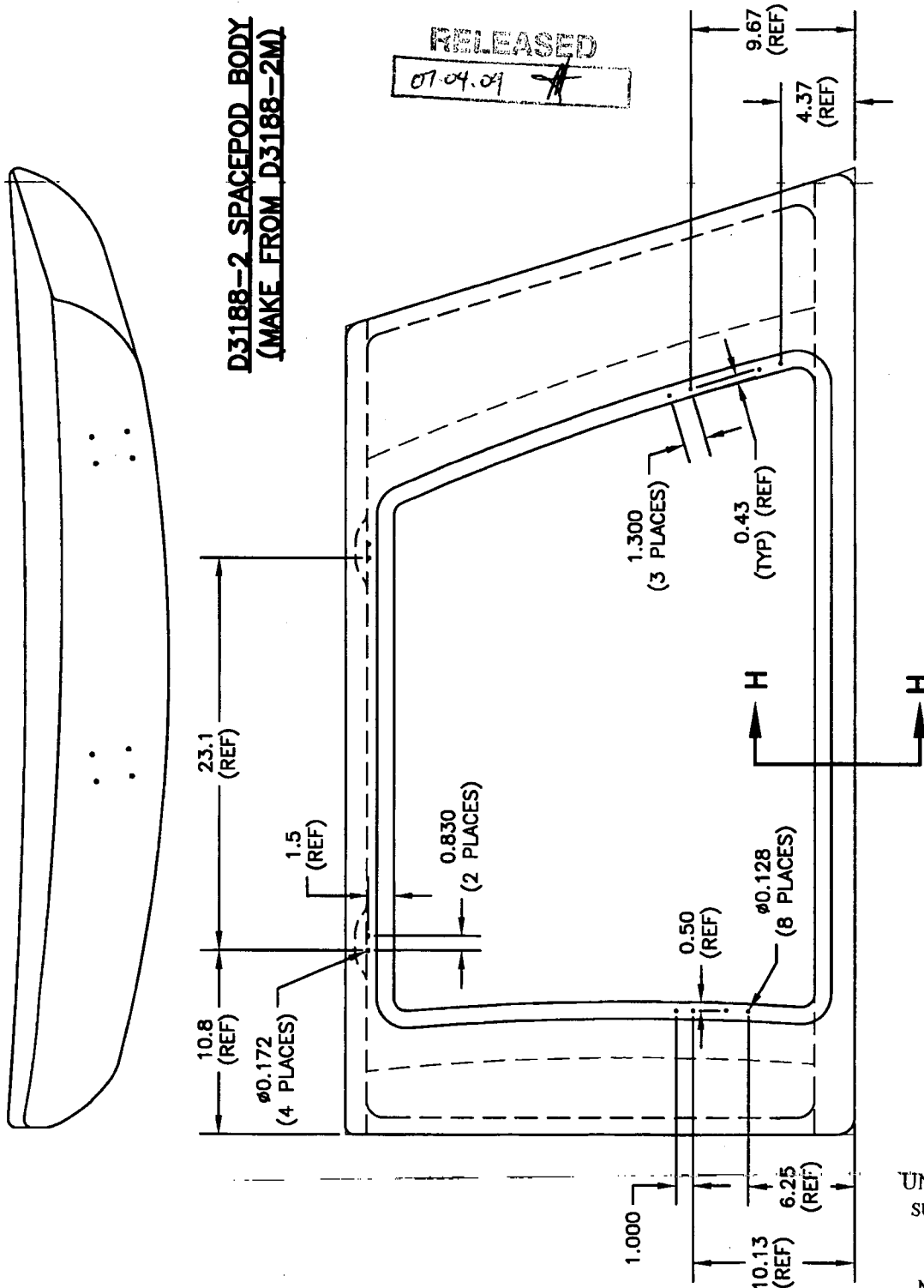
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

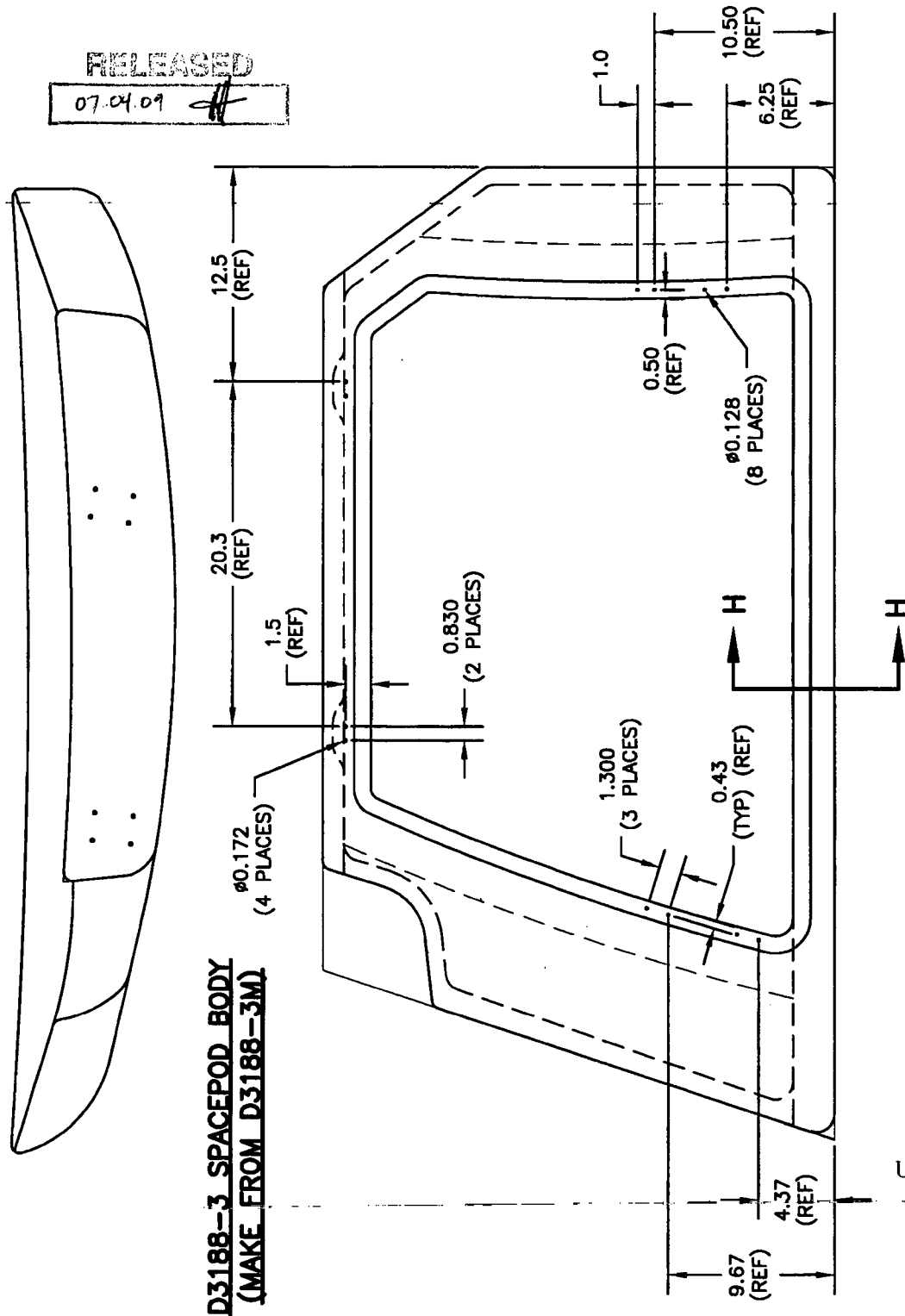
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

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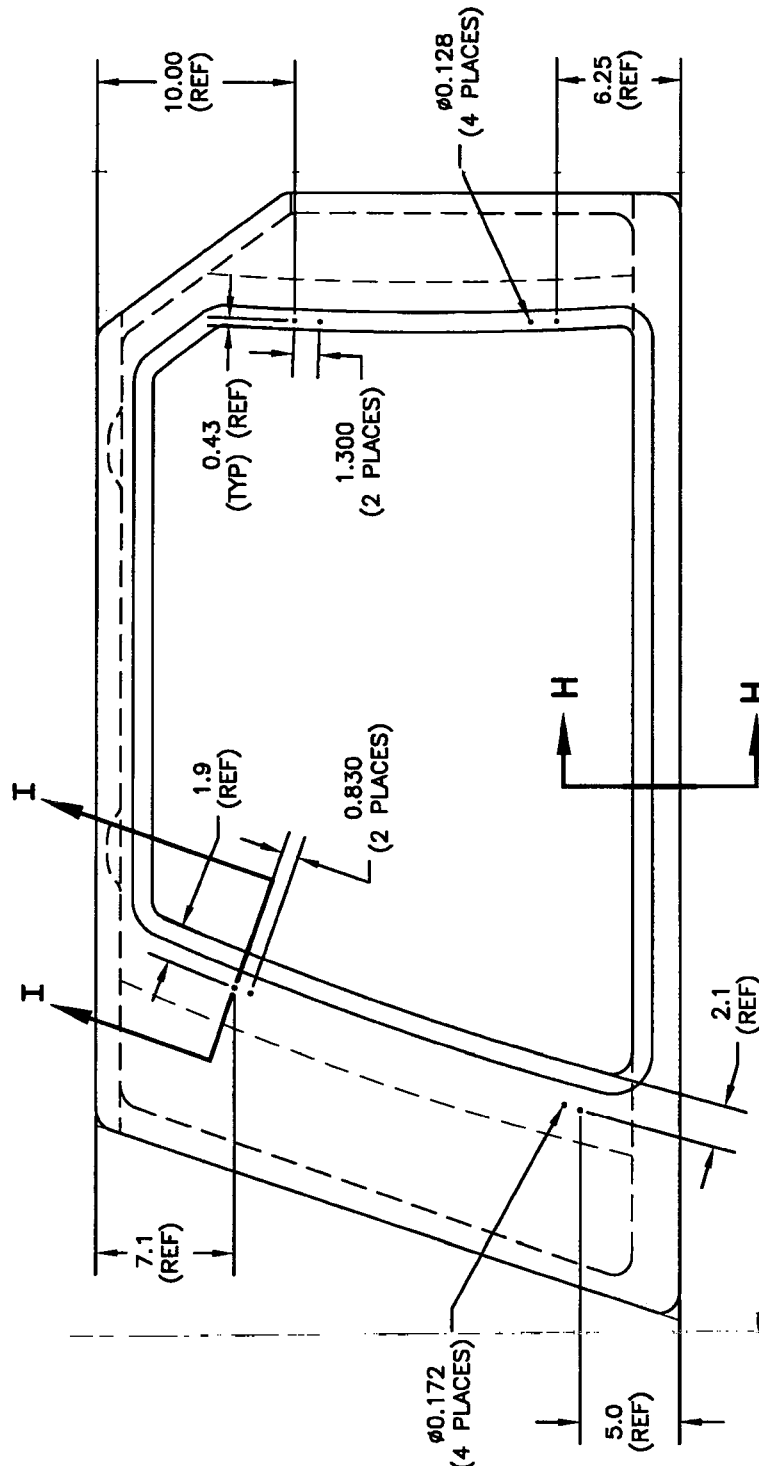
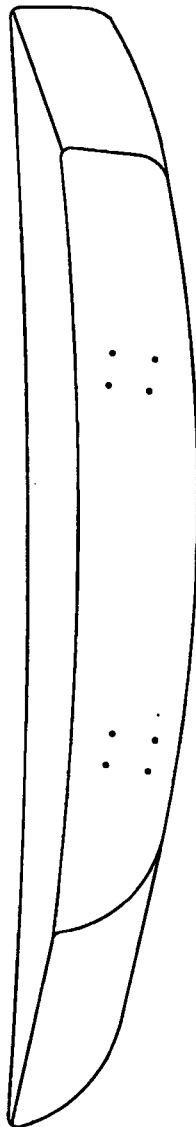
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

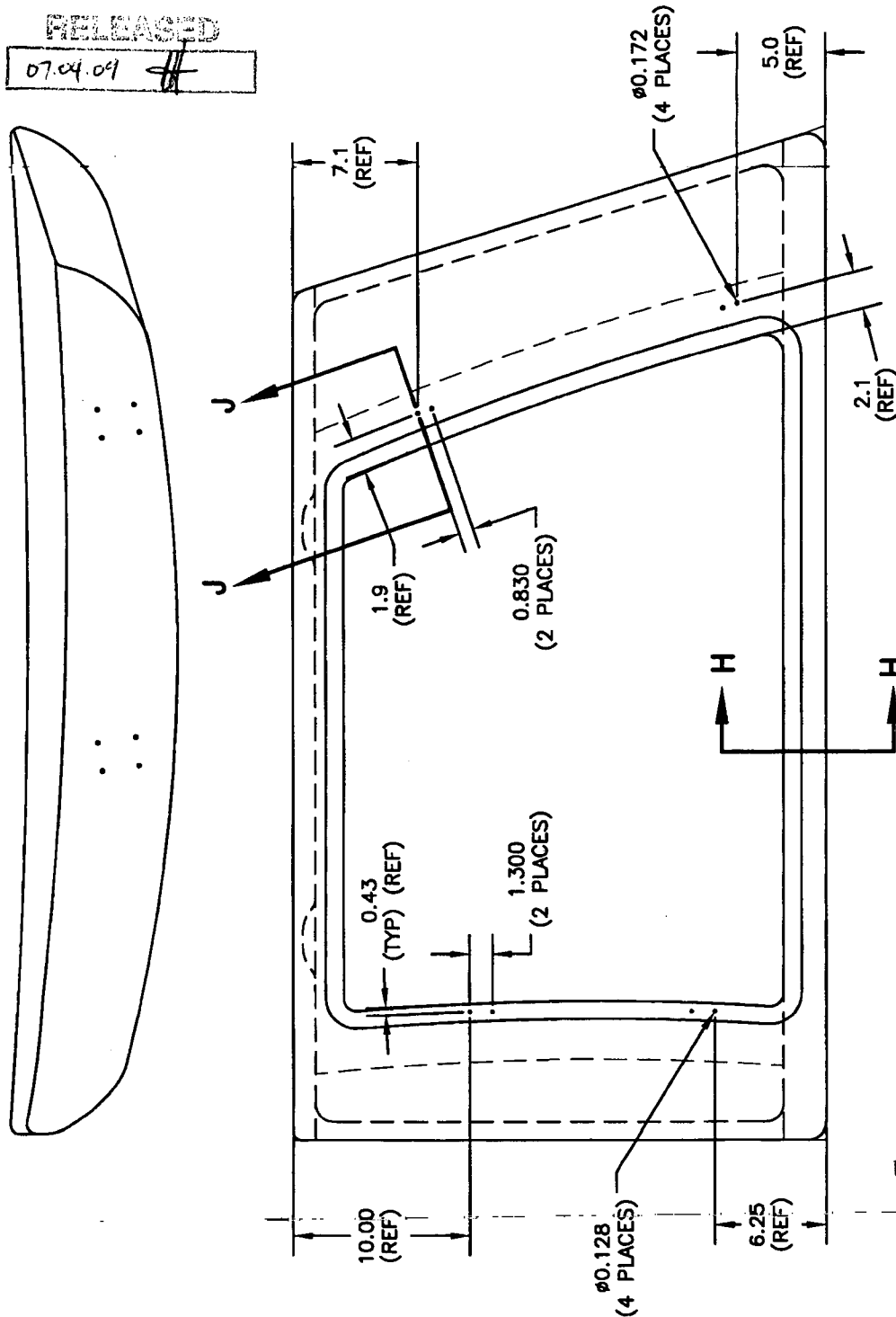
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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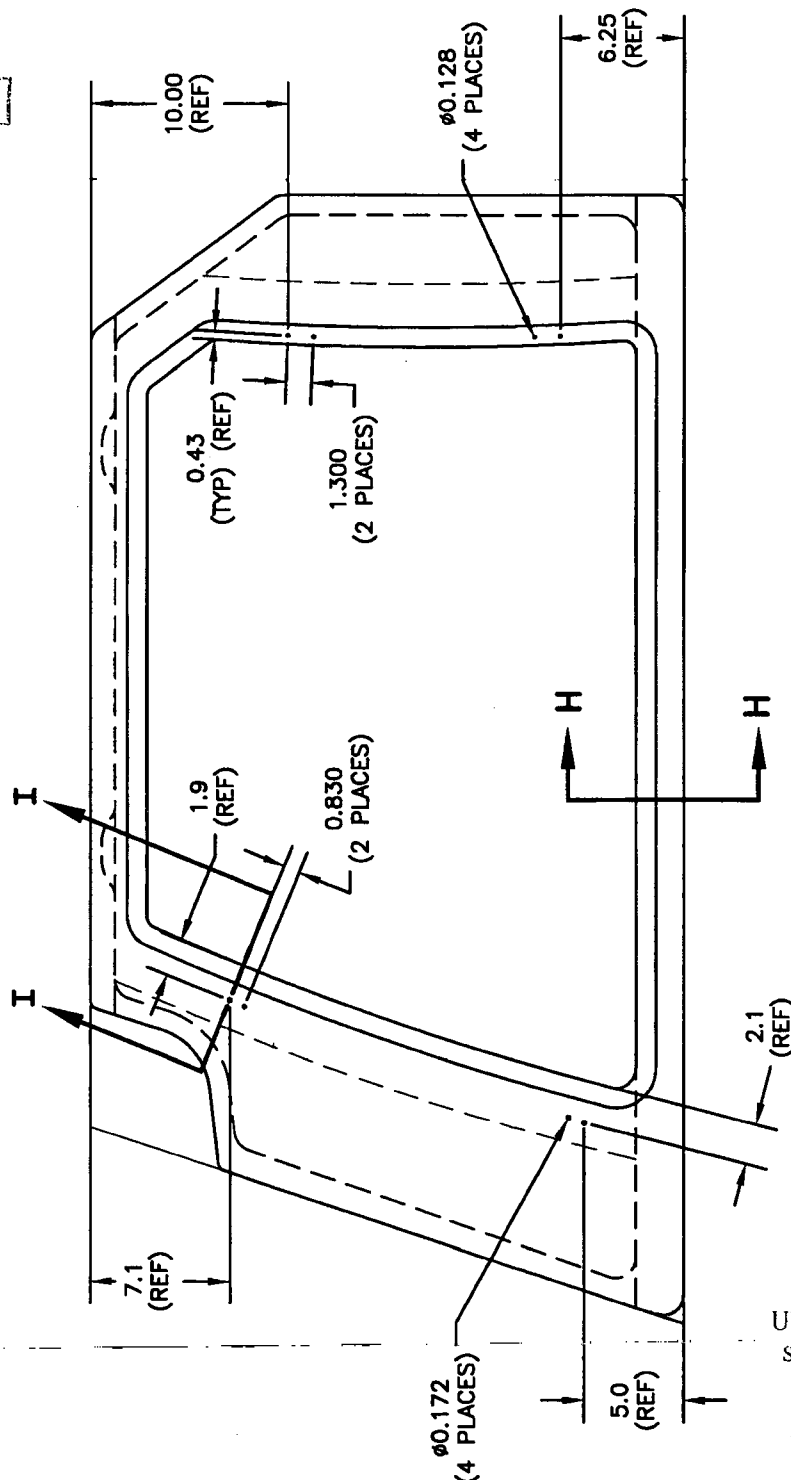
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.04.02

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

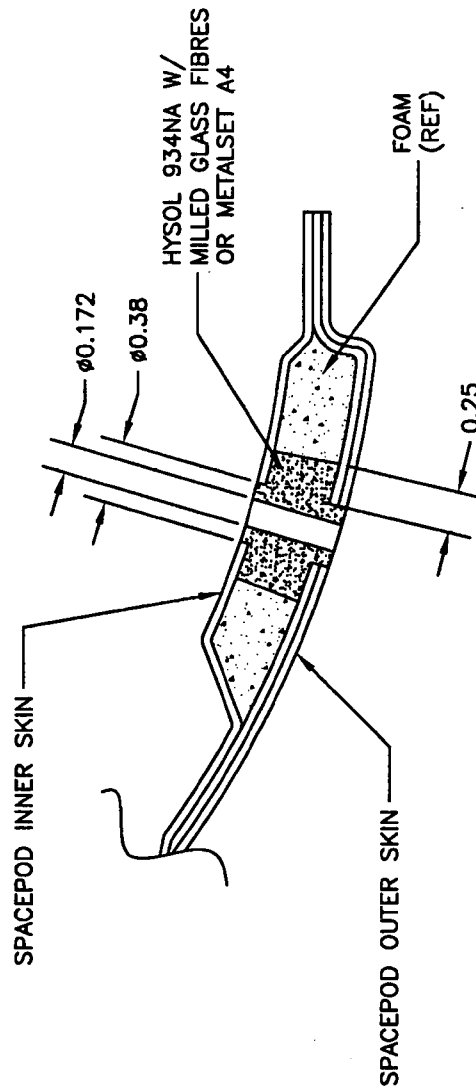
RELEASED

01.04.09 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Monday, 02/06/2008 4:37:21 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD DOOR RH
Job Number :	39650B		
Estimate Number :	12636		
P.O. Number :		Part Number :	D31864
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3186 REV.D
First Issue :	/ /	Project Number :	N/A
Previous Run :	39642B	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/07/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JUL 08.06.02</u>		
Comment :	Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	39650B01	SPACEPOD DOOR RH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

B 39650B1

mf 08-09-26

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

BL 08-09-25

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08-09-25

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D350-600-242 B39650

08-09-25

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



mf 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



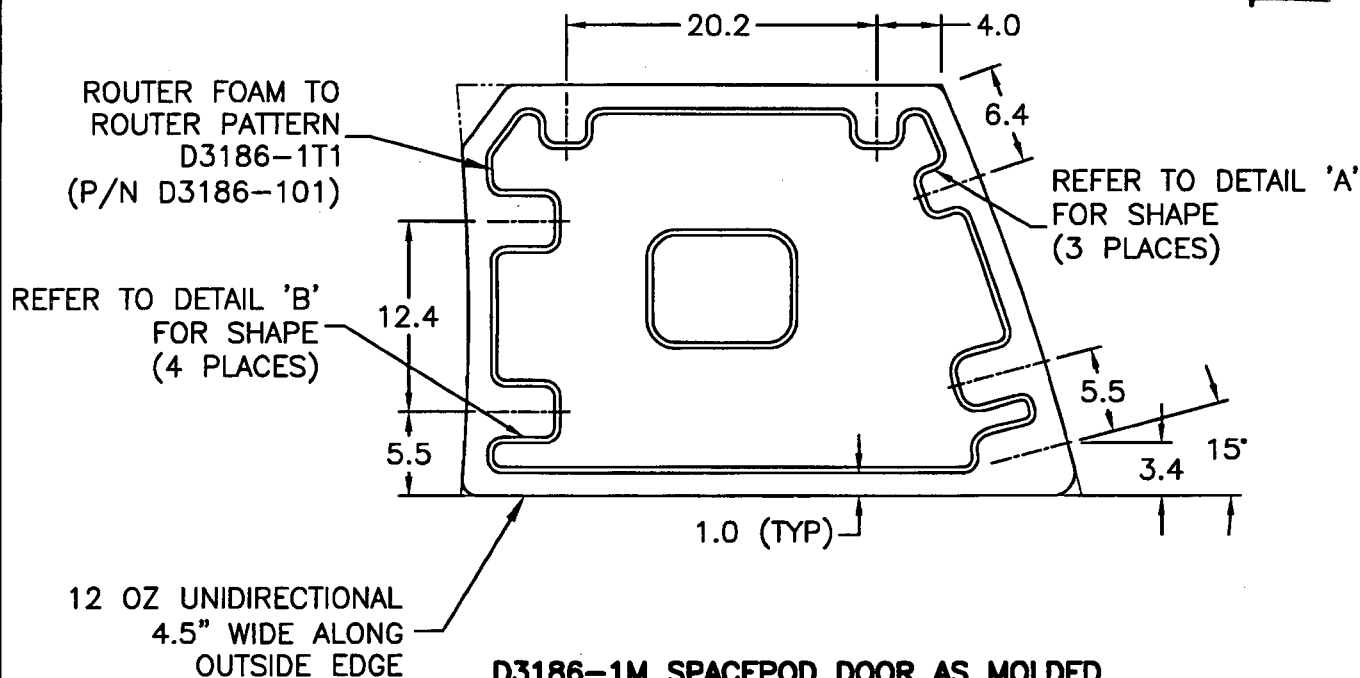
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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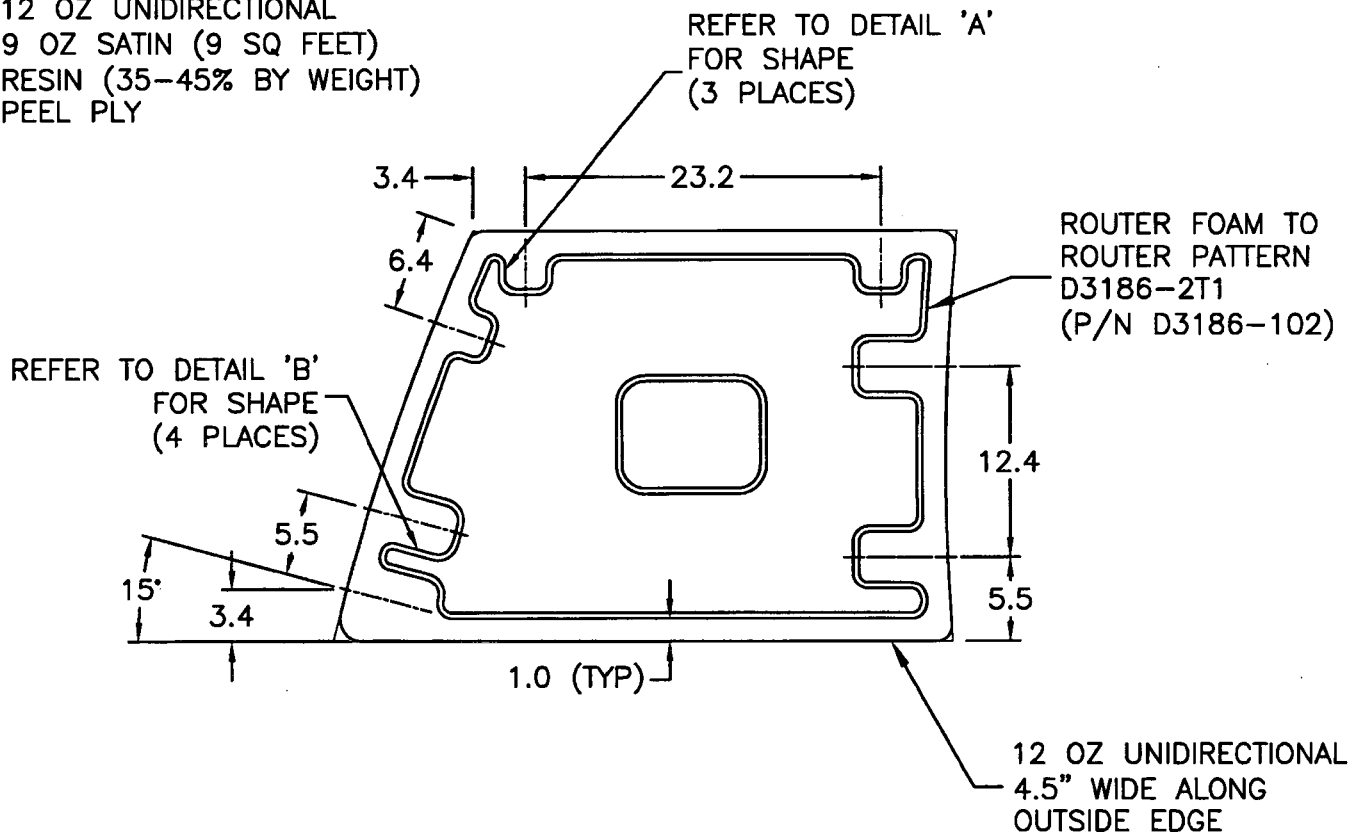
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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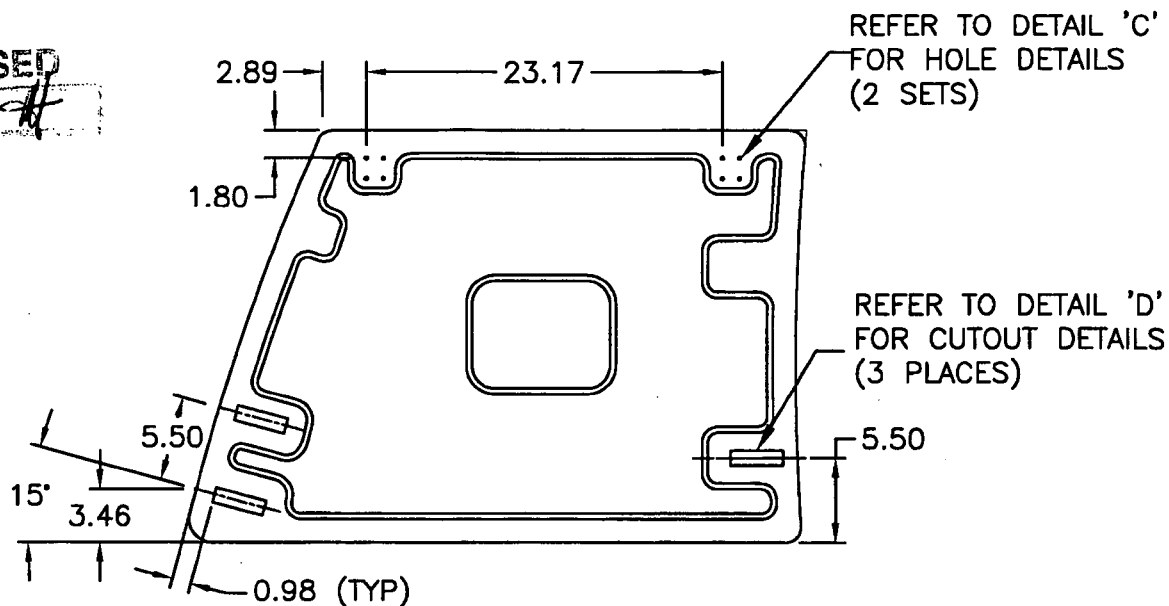
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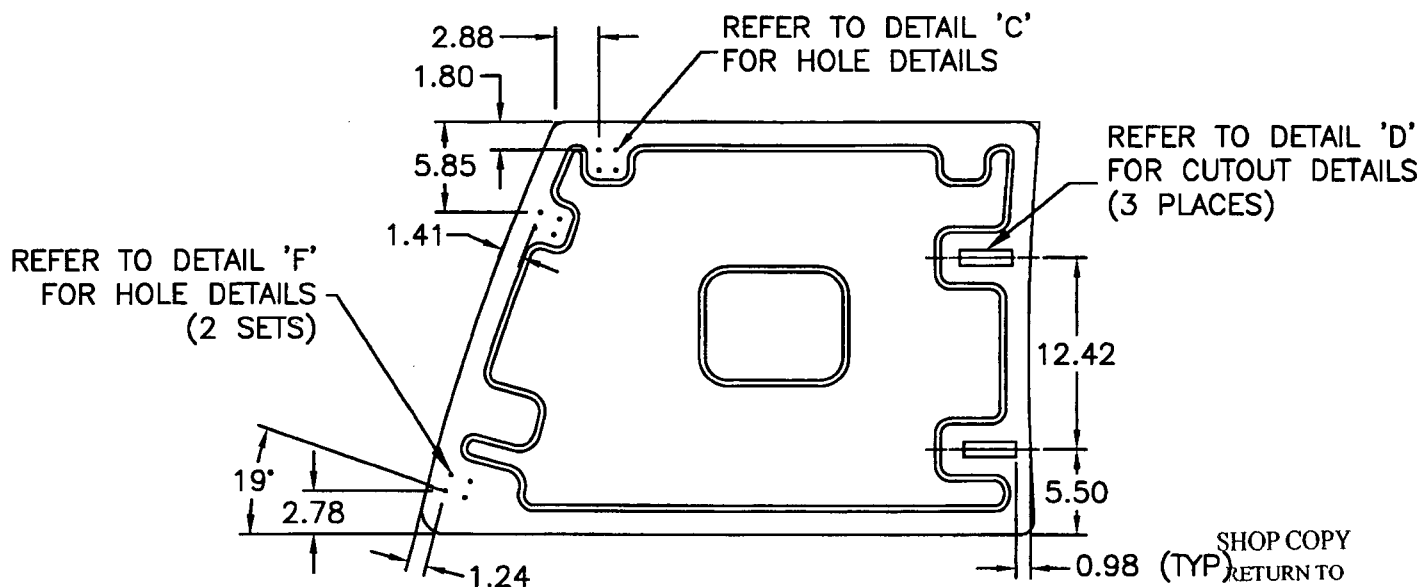
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

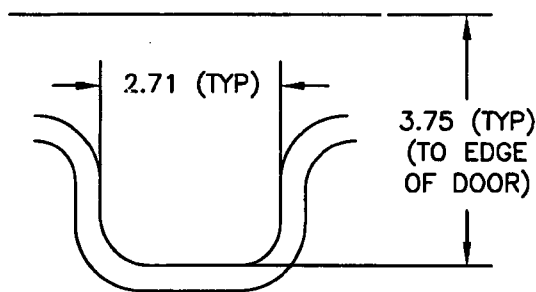
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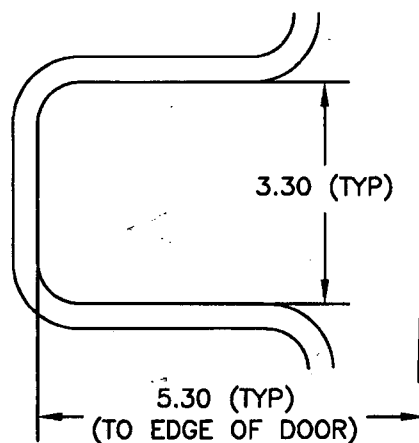
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS



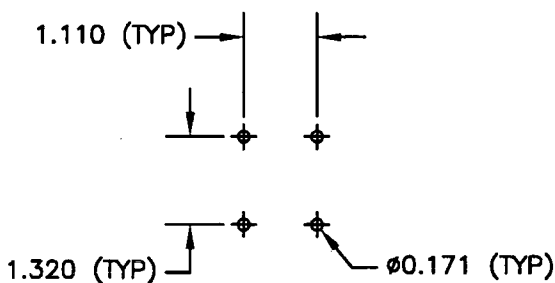
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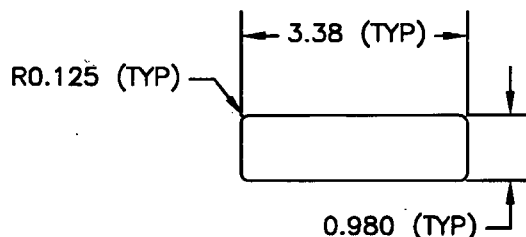
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RELEASED

07.02.27 [Signature]

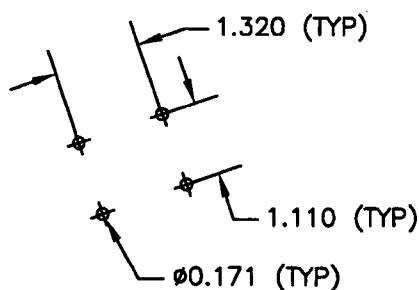


DETAIL C

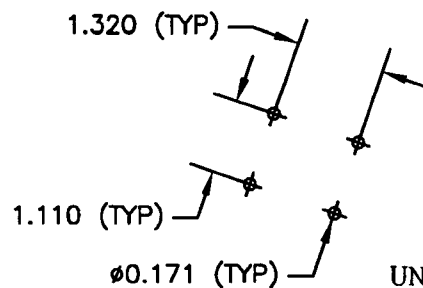


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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NOTES:

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Date: Monday, 02/06/2008 4:37:23 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD DOOR RH
Job Number :	39650B01		
Estimate Number :	12599		
P.O. Number :		Part Number :	D31862M
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3186 REV.D
First Issue :	/ /	Project Number :	N/A
Previous Run :	39642B01	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/07/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JUD 08.06.02</u>		
Comment :	Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 6496C208/06/04 ①

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

2.0	D31862P	Spacepod Door
-----	---------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 Visual inspection. Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: D350-600-242 B37650C 8/9/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:37:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 39650B01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/3098

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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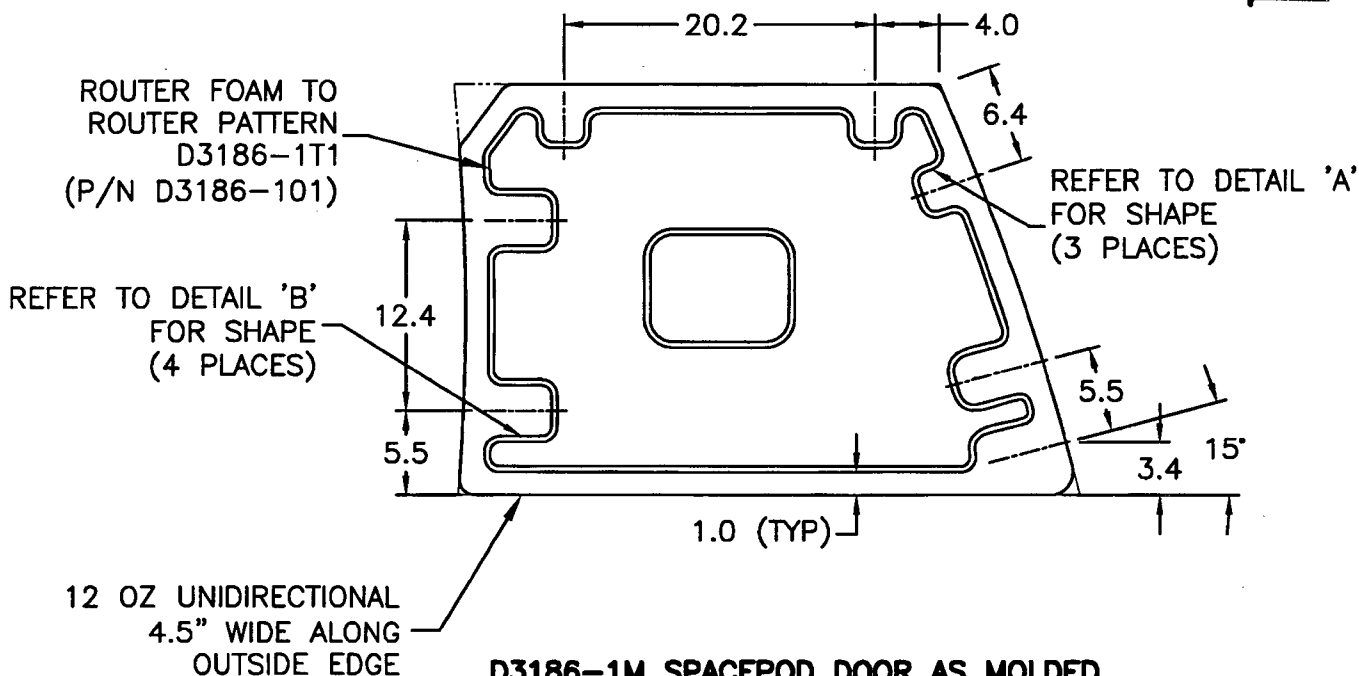
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
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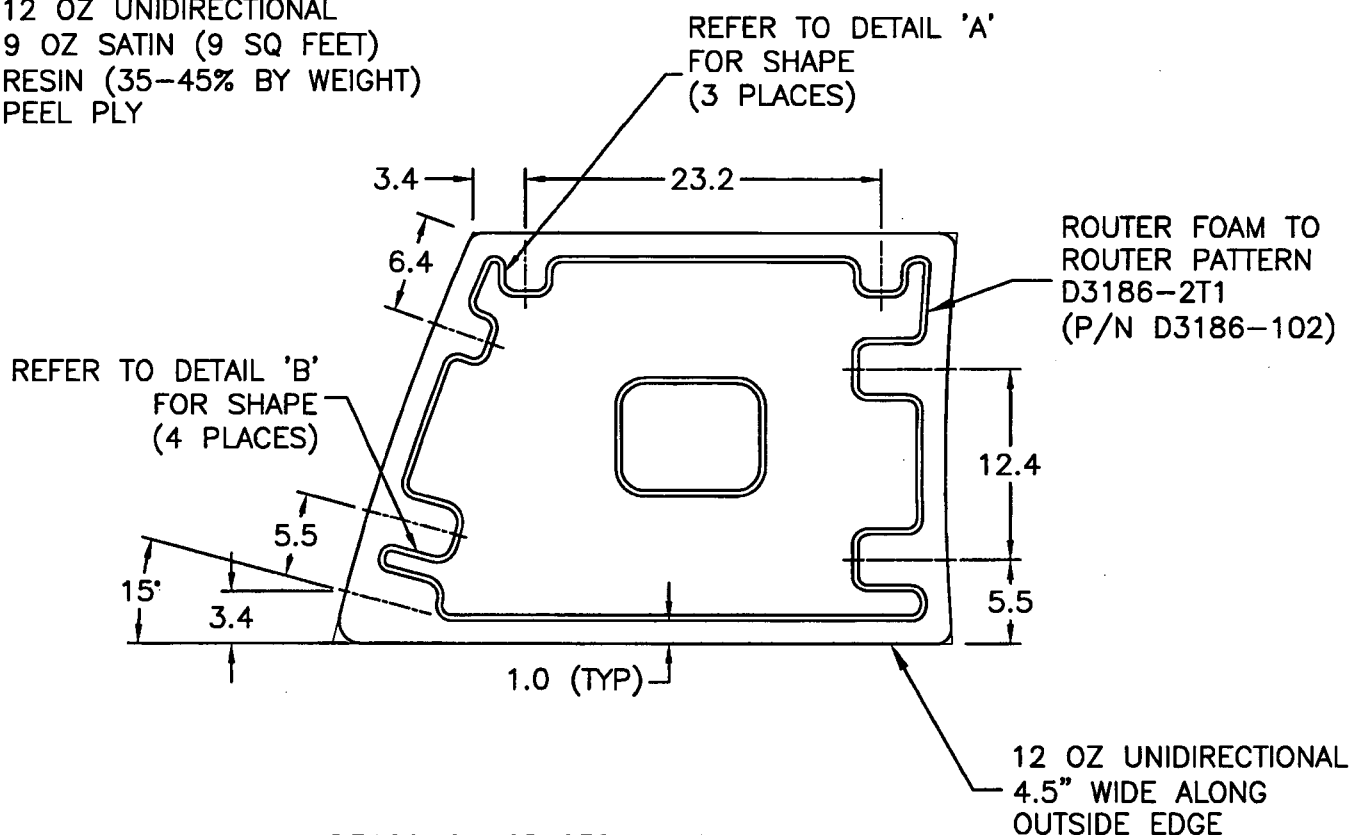
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CHECKED JB	APPROVED JH	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
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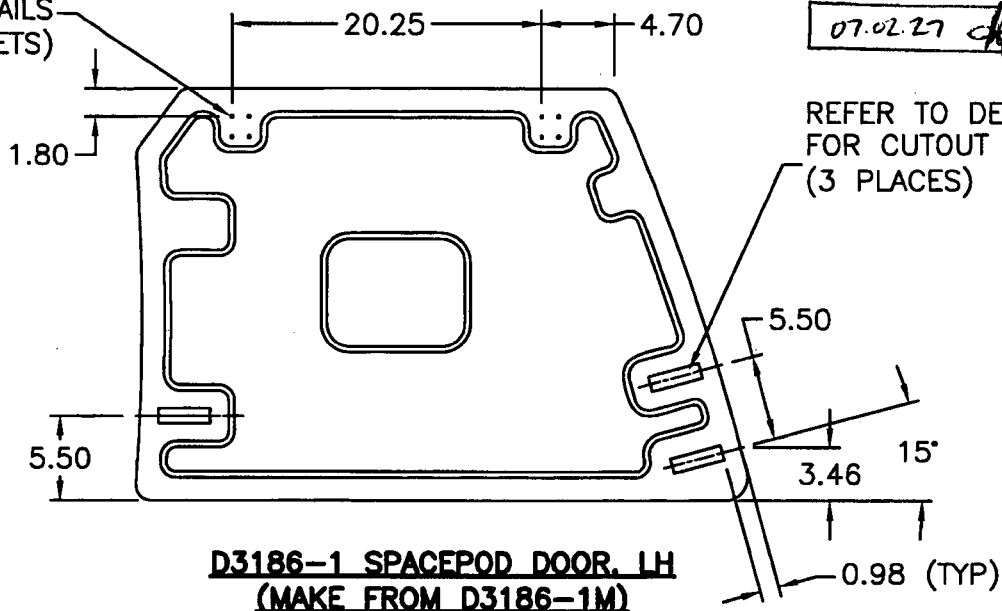
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CHECKED J	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**RELEASED**

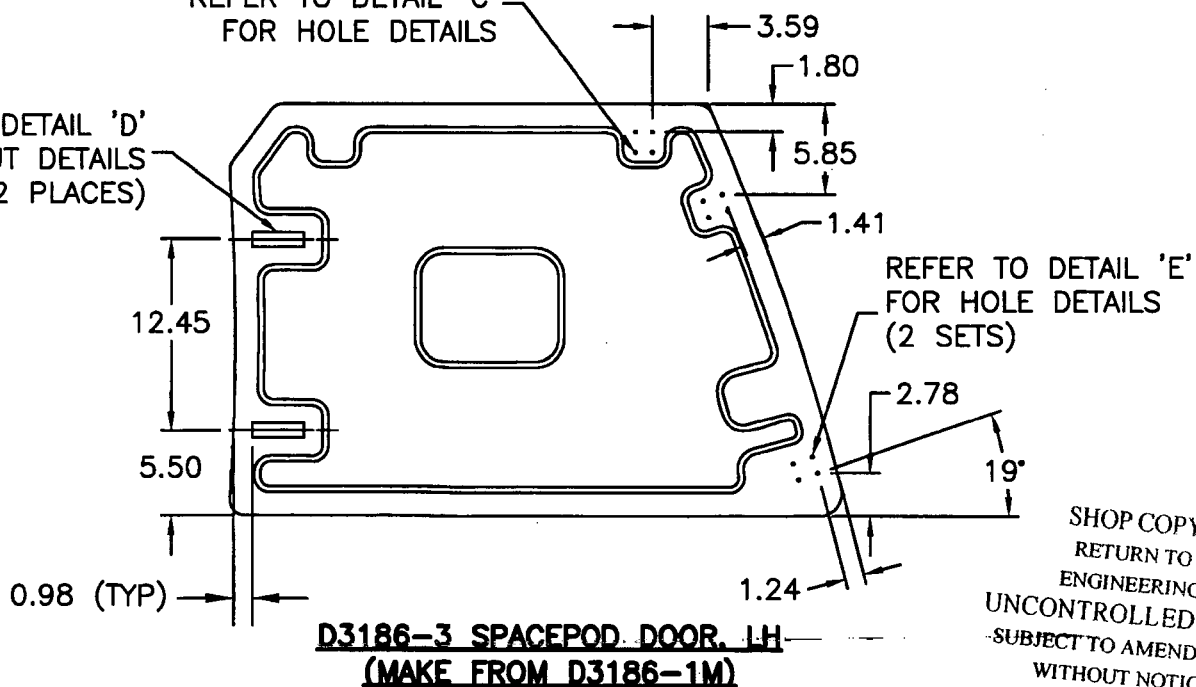
07.02.27

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

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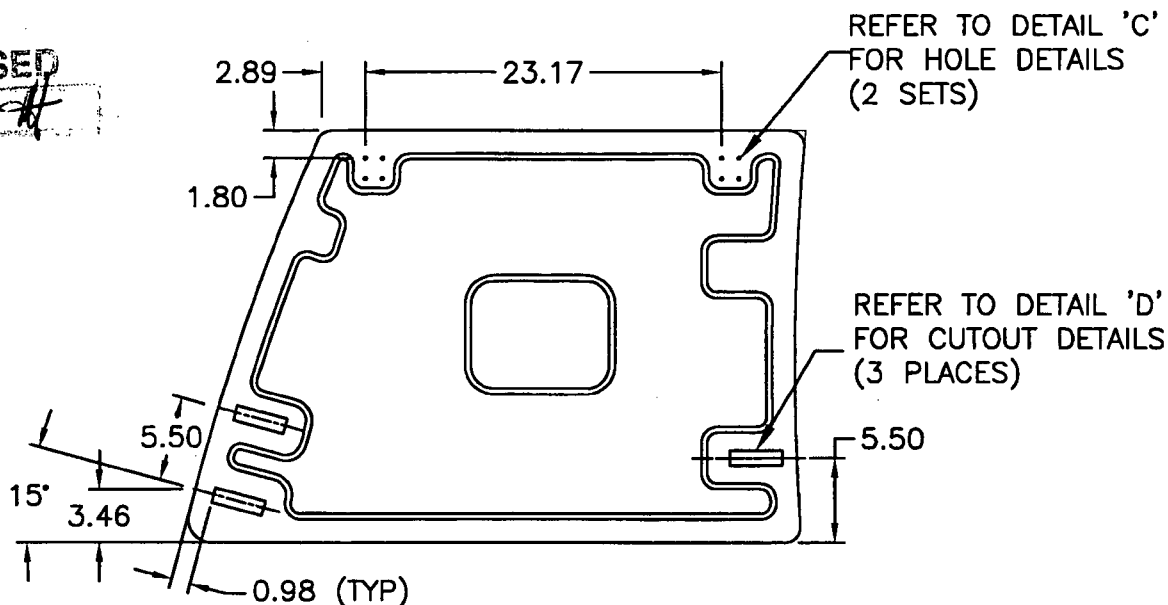
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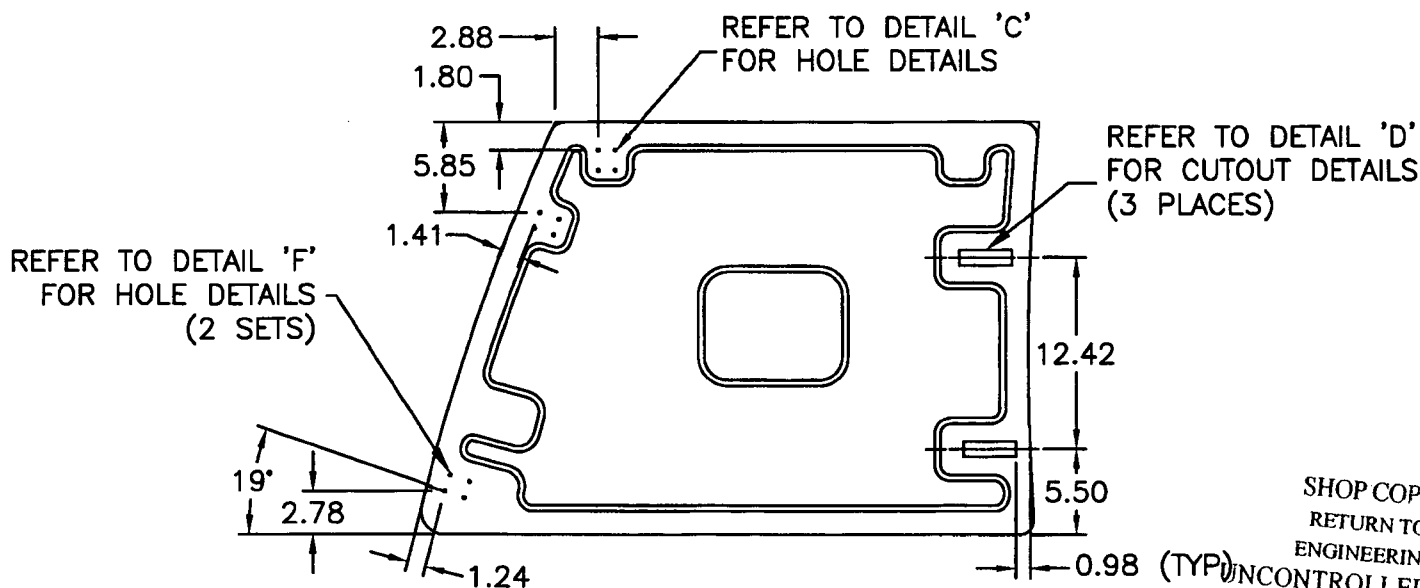
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
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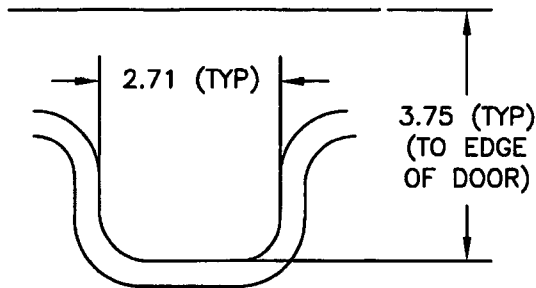
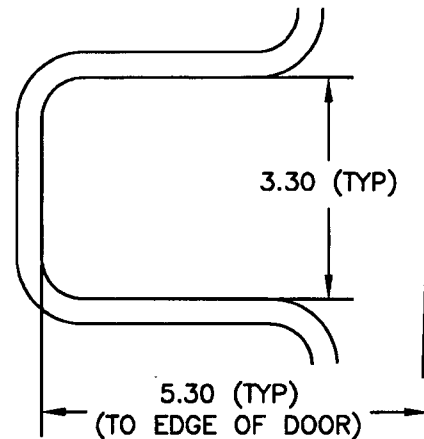
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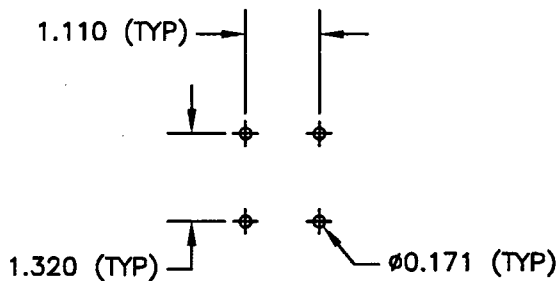
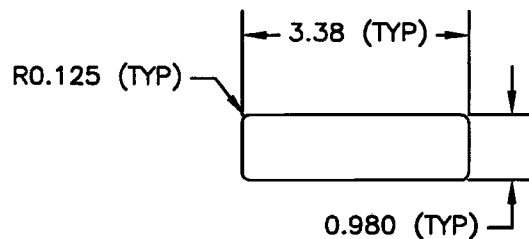
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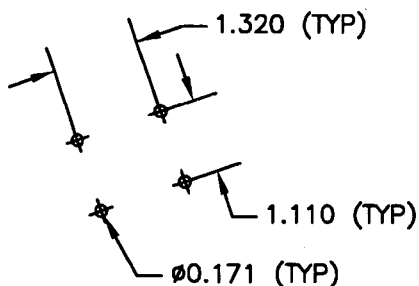
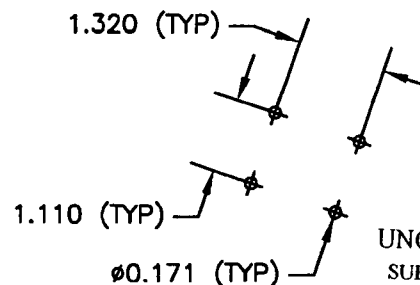
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F**

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Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200


Contact: Linda Lacelle

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12873
Customer #	DART

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
22/08/2008	04/06/2008	5821	C. Lavoie	PO00006496			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0055	D31882P Spacepod Body RH B39650A U de M : Each Dwg. Rév.: E Job: 43120 			
1	0	1	DKC134-0060	D31862P Spacepod Door RH B39650B0 U de M : Each Dwg. Rév.: D <div>No. lot Qté 43122 1</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Martine Muis 

Quality department

AQ-357

Date: Jeudi, 2008-06-05 13:35:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY R/H
Numéro Job :	43120	Numéro Article :	DKC134-0055
Numéro Soumission :	2587	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2008-06-05	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	-	Date Dûe :	2008-06-12
Job précédente :	43119	Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31882M		

Process Sheet Rév.: 06 Modification du planning afin d'y inclure le
N° I.G 0008 (Primer)

Produit additionnel

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE		
Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.		
Date: <u> </u> Heure Début: <u> </u> Heure Fin: <u> </u> Sceau: <u> </u>		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Date: Jeudi, 2008-06-05 13:35:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43120

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
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Commentair Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish

2-6476-1

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional

N° de Lot: 1-6258-1

9.0	AAC0633	WR1850 ROVING 18 OZ x 50"
-----	---------	---------------------------

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-6476-3

10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 16/06/08 Heure Début: 1:00 Heure Fin: 1:55 Sceau:



12.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21244-1

14.0	AAC0673	Fibre de verre Miapoxy 66
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Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Jeudi, 2008-06-05 13:35:39
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 43120

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: 4 Juin 08 Heure Début: 10:30 Heure Fin: 10:35 Sceau:

16.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 4 Juin 08 Heure Début: 10:30 Heure Fin: 11:45 Sceau:

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 4 Juin 08 Heure Début: 11:45 Heure Fin: 12:00 Sceau:

Curing Début: 10:30 Curing Fin: 12:00

18.0

AAC0457












ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total.: 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 1-6292-1

Date: Jeudi, 2008-06-05 13:35:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 43120	Numéro Article: DKC134-0055	
Numéro Job: 		
# Séq.: 19.0	Machine ou Opération: FAB GÉNÉRALE 3	Description: FABRICATION GÉNÉRALE DART
		
Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL Tailler le Foam Core 1" selon le plan de découpe et les gabarits Date: <u>15-07-08</u> Heure Début: <u>11:00</u> Heure Fin: <u>1:30</u> Sceau: 		
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-21249-1</u>		
21.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6270-1</u>		
22.0	FINITION 3	FINITION PIÈCE DART
		
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART <u>15-7-08</u>  Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.		
23.0	AAC0452	Polybond B46F
Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: <u>1-6520-1</u>		
24.0	FINITION 3	FINITION PIÈCE DART
		
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide du Polybond, coller ensemble les deux surfaces scellées Disposer des poind sur les pièces pour conserver une pression de collage. Laisser sécher pour un minimum de deux heures. Quantité: <u>1</u> Date: <u>16-7-08</u> Sceau:  		

Date: Jeudi, 2008-06-05 13:35:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43120

Numéro Article: DKC134-0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 15-7-08 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21249-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promoté 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs

FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promoté N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.













Date: 17-10-08 Sceau: _____



Initiales: ADT











Date: Jeudi, 2008-06-05 13:35:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H.	
- Numéro Job: 43120		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
30.0	AAC0452	Polybond B46F	
Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-6520-1</u>			
31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation du Poly bond. Date: <u>4-8-08</u> Heure Début: <u>10:20</u> Heure Fin: <u>10:30</u> Sceau: 			
32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES			
Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.			
Date: <u>4-8-08</u> Heure Début: <u>10:35</u> Heure Fin: <u>11:00</u> Sceau: <u>S.V</u>  			
33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200			
Laisser sécher pendant 2 heures minimum.			
Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.			
Date: <u>4-8-08</u> Heure Début: <u>11:00</u> Heure Fin: <u>11:10</u> Sceau: <u>S.V</u>  			
Curing Début: <u>10:30</u> Curing Fin: <u>11:40</u>			

Date: Jeudi, 2008-06-05 13:35:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
-Numéro Job: 43120		Numéro Article: DKC134-0055	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens N° de Lot: <u>1-6284-1</u>			
35.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
36.0	FINITION 3	FINITION PIÈCE DART	
 			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FINITION GÉNÉRALE Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond Date: <u>5-8-08</u> Heure Début: <u>8:45</u> Heure Fin: <u>10:45</u> Sceau: 			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
 			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART <u>5-8-08</u> 			
38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-21359-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6270-1</u>			
40.0	FINITION 3	FINITION PIÈCE DART	
 			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART <u>05-08-08</u>  Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core Laisser sécher pendant minimum deux heures.			

Date: * Jeudi, 2008-06-05 13:35:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43120

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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41.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21359-1

43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 6-8-08 Heure Début: 2:50 Heure Fin: 2:53 Sceau:



44.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 6-8-08 Heure Début: 3:15 Heure Fin: 4:15 Sceau: S.V



45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant: _

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2008-06-05 13:35:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43120

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 6-8-08 Heure Début: 4:15 Heure Fin: 4:25 Sceau: 5.1



Curing Début: 3:15 Curing Fin: 7:30

46.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 7-8-08 Heure Début: 2:00 Heure Fin: 2:20 Sceau: 34



47.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, percer les 8 dégagement de $\varnothing .745"$ pour les spacers N° D2213 (ne pas percer la peau extérieur de la pièce)

Date: 8-8-08 Heure Début: 7:40 Heure Fin: 8:40 Sceau: 34



48.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

49.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21359-1

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-2956-1

Date: Jeudi, 2008-06-05 13:35:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43120

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 13-8-08 Heure Début: 8:35 Heure Fin: 8:40 Sceau:



52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)

Spacer N° D2213

N° de Lot: 1-6688-2

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÉCES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

Date: 13-8-08 Heure Début: 8:40 Heure Fin: 9:20 Sceau:



Curing Début: 8:40 Curing Fin: 3:30

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21359-1

Jeudi, 2008-06-05 13:35:40
Marc Dubé

Feuille de Procédé

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Client: DART Dart Aerospace Ltd.

Job: 43120



Description :

Machine ou Opération:

PRÉPARATION DU MATÉRIEL DART




PRÉPARATION 3



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 12-8-08 Heure Début: 10:20 Heure Fin: 10:25 Sceau: 

LAMINAGE PIÈCE DART

57.0

LAMINAGE.




Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièces. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: 12-8-08 Heure Début: 10:25 Heure Fin: 11:35 Sceau: 

Curing Début: 10:25 Curing Fin: 3:15

FINITION PIÈCE DART

58.0

FINITION 3



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

59.0

AAC0683

Dupont Primer N° 7704S

Commentaire Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6518-1

60.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentaire Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S

Date: Jeudi, 2008-06-05 13:35:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43120

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

61.0 PRIMER APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 18/08/08 Sceau:

Quantité: 1 Date: AUG 20 2008 Sceau:

Quantité: 1 Date: AUG 21 2008 Sceau:

Quantité: Date: Sceau:

Nettoyer 18/08/08
Nettoyer 20/08/08



Rework

62.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 22/8/08 Sceau: Initiales: JS

63.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.


Quantité: 1 Date: 2-8-08 Sceau:

Quantité: Date: Sceau:

Date: Jeudi, 2008-06-05 13:35:45
 Utilisateur: Marc Dubé
Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : SPACEPOD DOOR
Numéro Job : 43122	Numéro Article : DKC134-0060
Numéro Soumission : 2610	Numéro Dessin : D3186
Numéro B.A. :	Projet Numéro : DKC134
Cette fois : 2008-06-05 No. B.V. :	Révision dessin : D
Prsht Rev. : NC	Matériel : Fibre 7781 et Résine 411-350
Prem. fois : 1 Type :	Date Dûe : 2008-06-12 Qté: 1 UdM: UNITE
Job précédente : 43121	
Écrit par : _____	
Vérifié & Approuvé par : _____	
Commentaires : N° de pièce Dart Aerospace : D31862M	

 Process Sheet Rév.: 02 Modification du planning afin d'y inclure le
 N° I.G 0008 (Primer)
Produit additionnel
 Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. Date: 25 Jun 08 Heure Début: 11:30 Heure Fin: 11:55 Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 43122

Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish

8.0	AAC0443	Fiberglass 12 oz Unidirectional
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Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-6258-1

9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 16-6-08 Heure Début: 8:30 Heure Fin: 9:00 Sceau:

11.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 1-6270-1

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-21011-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26-6-08 Heure Début: 1:20 Heure Fin: 1:25 Sceau:

Feuille de Procédé

Client: DART - Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 43122

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE.



LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date 26-6-08 Heure Début: 1:25 Heure Fin: 1:40 Sceau:  

15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE





Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date 26-6-08 Heure Début: 1:40 Heure Fin: 1:45 Sceau:  

Curing Début: 1:25 Curing Fin: 7:40

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21143-1

Date: Jeudi, 2008-06-05 13:35:45

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Número Job: 43122

Número Article: DKC134-0060

Número Job:



# Séq.:	Machine ou Opération:	Description :
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18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: 1^{er} Juin 08 Heure Début: 8:45 Heure Fin: 9:00 Sceau:



19.0	AAC0452-	Polybond B46F
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Commentair Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F N° de Lot: 1-6520-1

20.0	DKC134-0057	Foam Core N° D3186-102 (Porte D3186-2)
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Job: 43189

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Faire l'inspection du positionnement par le département de la qualité

Date: 10-7-08 Sceau:  Initiales: CG.

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 10-7-08 Heure Début: 2:30 Heure Fin: 2:45 Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 43122

Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

22.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond

Date: 20-08 Heure Début: 2:45 Heure Fin: 2:55 Sceau:  Curing Début: 2:30 Curing Fin: 3:40

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9N° de Lot: 1-6270-1


24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.N° de Lot: 1-21249-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11-7-08 Heure Début: 12:35 Heure Fin: 12:40 Sceau: 

Date: Jeudi, 2008-06-05 13:35:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43122

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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26.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 11-7-08 Heure Début: 12:40 Heure Fin: 1:15 Sceau:  

27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 11-7-08 Heure Début: 1:15 Heure Fin: 1:25 Sceau:  

Curing Début: 12:40 Curing Fin: 7:30

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 15-7-08 Heure Début: 2:15 Heure Fin: 2:20 Sceau: 

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 43122

Numéro Article: DKC134-0060

-Numéro Job:



Séq.: Machine ou Opération: Description :

29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 15-7-08 Heure Début: 2:25 Heure Fin: 2:55 Sceau:

30.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1390 UNITE(s)/Unit Total : 0.1390 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-6518-1

31.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

Dupont Activator - Reducer Chromabase N° 7775S

32.0

PRIMER

APPLICATION DE PRIMER

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 15/08/08 Sceau: Quantité: 1 Date: 18/08/08 Sceau: Quantité: 1 Date: 19/08/08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Nettoyage 15/08/08
Nettoyage 18/08/08 gicote
gicote

33.0

INSPECTION 3

INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

Quantité: 1 Date: 20-8-08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 43122

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

34.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1

Date: 20-8-08

Sceau: 

Quantité: _____

Date: _____

Sceau: _____